

Work Order ID 137347

September 24, 2015 2:38:18 PM

137347For an order shipping
Oct 12/15

Page 1

Item ID: D3805-045

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Run-on Landing Wearplate Aft

Start Date: 9/24/2015 Start Qty: 5.00

Required Date: 10/8/2015 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: SILDate: 20150924

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3805

C

100

0.00

100

Large Fab

Memo

0.03

Large Fab

1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805
2059 B Hardcoat Welding Rod
BATCH#: 1380452-weld D3806-5 to D3805-5 together as per dwg D3805
304 S.S. Welding Rod
BATCH #: 128077

3-Transfer drill holes in bar

CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

③

15-10-03

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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		OTHER :																																																																					

137347

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

5

Cust Item ID:

5

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150

0.00

150

Small Fab

Small Fab

Memo

0.01

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 dwg D3805.

TEXTURED COATING B#: 133152

NAS

1

9-8

DAS

41

9-2

15-10-8

160

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

160

QC

Quality Control

Memo

0.00

DAS

!

9-85

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Work Order ID 137347

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Page 3

Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Run-on Landing Wearplate Aft
Start Date: 9/24/2015 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 10/8/2015 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>FP002</u>	0.00				<u>8</u>		<u>DAS 6 9-89</u>	
170									
Packaging	Memo	0.00							
Packaging	LOCATION : FP002								
180	QC21- Final Inspection - Work Order Release	0.00							
180						<u>MLJ</u>		<u>OCT 09 2015</u>	
QC	Memo	0.01							
Quality Control									

MF
15-10-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY			
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Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Picklist Print

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Page 1

Work Order ID: 137347

137347

Parent Item: D3805-045

D3805-045

Parent Item Name: Run-on Landing Wearplate Aft

Start Date: 9/24/2015

Required Date: 10/8/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC IPP REV:D 14.04.22 DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3805-5

Manufactured

No

100

Each

8.0000

1

5

D3805-5

Plate

15-10-07

JBL

Location

Loc Qty

Loc Code

WA002

8

134087

8

D3806-5

Manufactured

No

100

Each

0.0000

1

5

D3806-5

Bar

15-10-05

JBL

134918

J

8

7

6

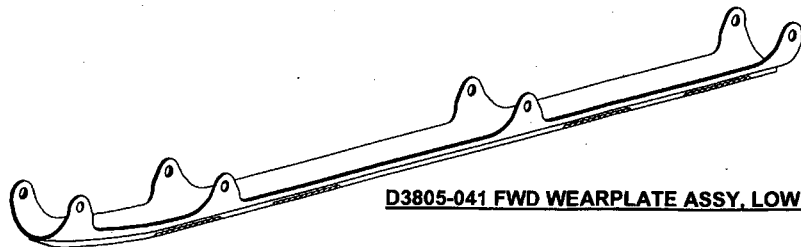
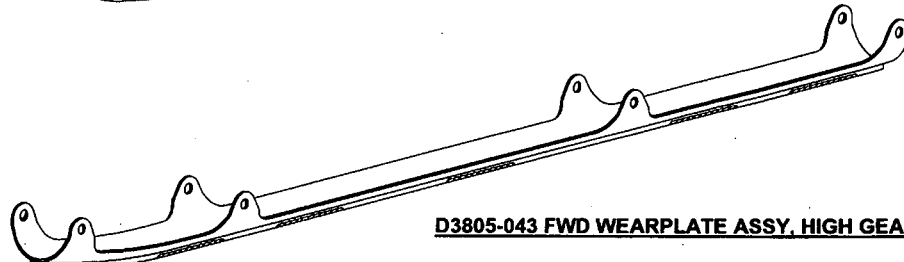
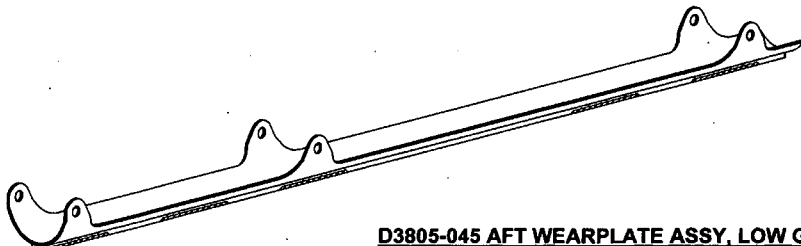
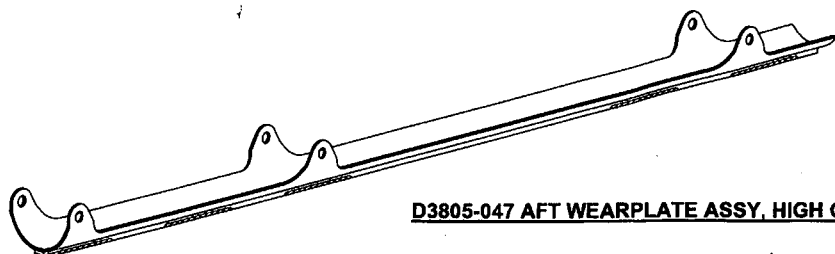
5

4

3

2

1

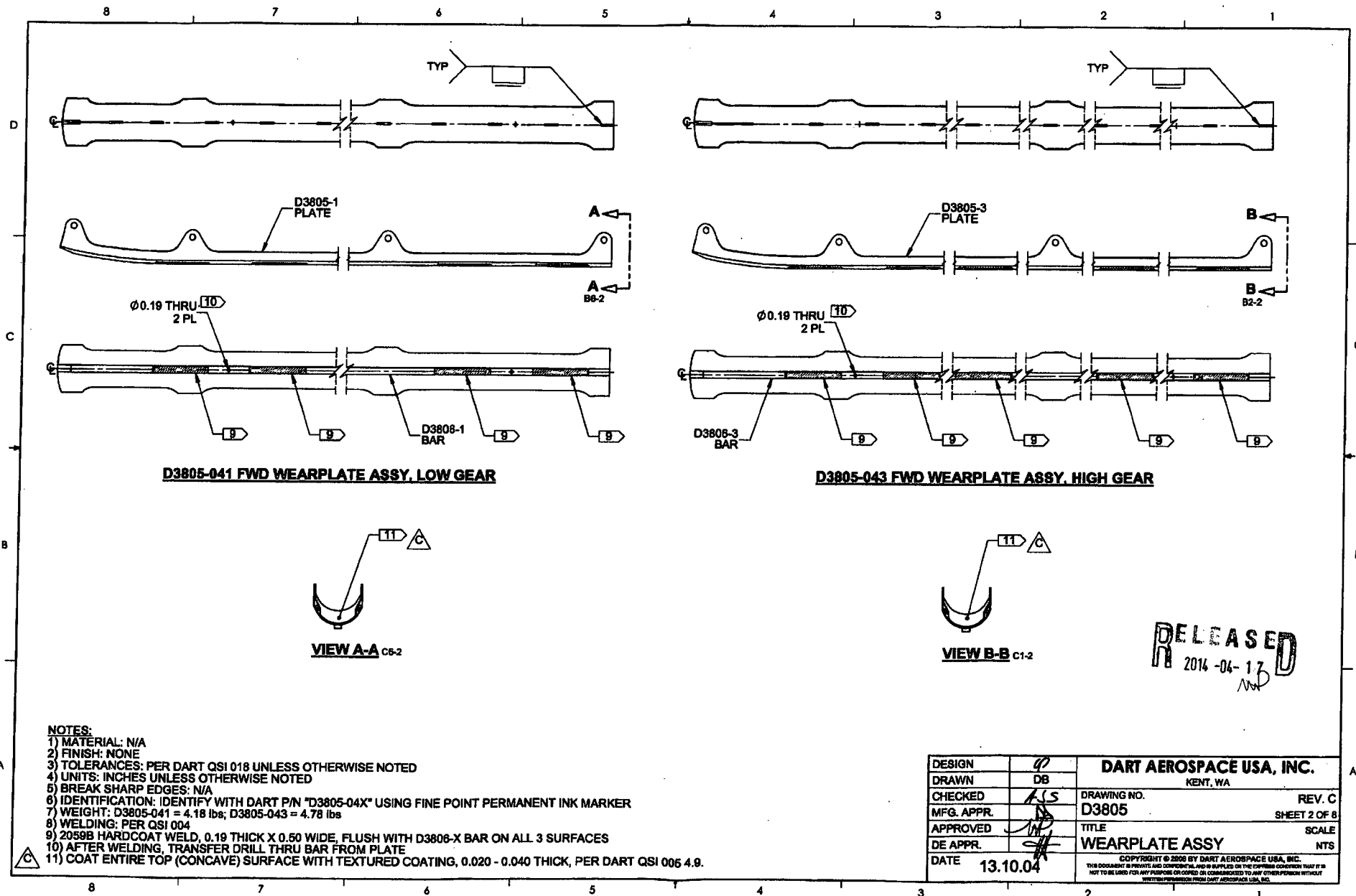
**D3805-041 FWD WEARPLATE ASSY, LOW GEAR****D3805-043 FWD WEARPLATE ASSY, HIGH GEAR****D3805-045 AFT WEARPLATE ASSY, LOW GEAR****D3805-047 AFT WEARPLATE ASSY, HIGH GEAR**

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT

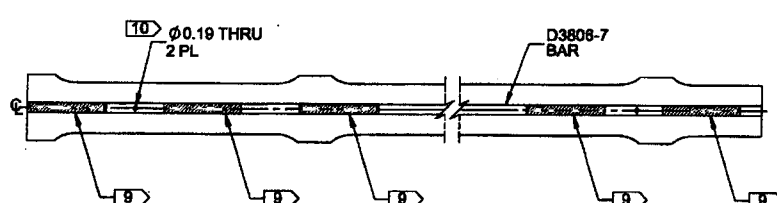
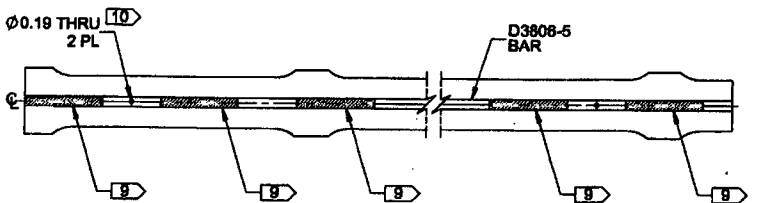
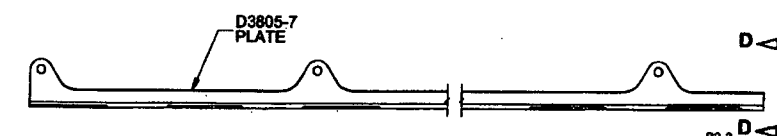
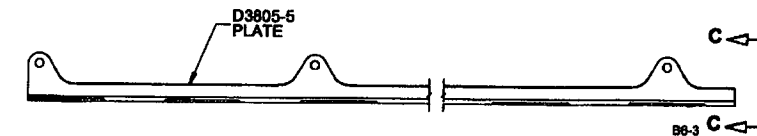
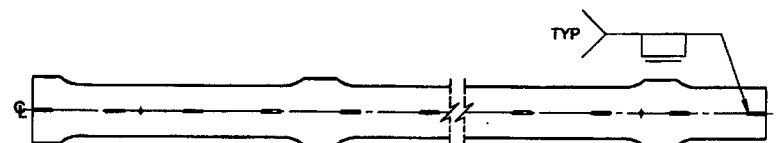
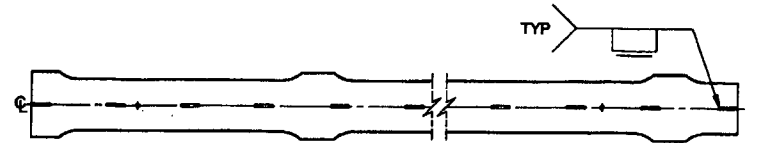
RELEASED
2014-04-17

120150924 SH 137347

C	REMOVE ITEMS 19, 20, 21, 22 AND 32 FROM BOM (ZN C4-1), REVISE NOTE 11, SHEETS 2&3 (ZN A8-2, B2-2, B6-2, A8-3, B2-3, B6-3)	DB	13.10.04
B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	ASS	D3805	SHEET 1 OF 8
APPROVED	ASS	TITLE	SCALE
DE APPR.	ASS	WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



8 7 6 5 4 3 2 1



D3805-045 AFT WEARPLATE ASSY.

D3805-047 AFT WEARPLATE ASSY.



VIEW C-C C5-3



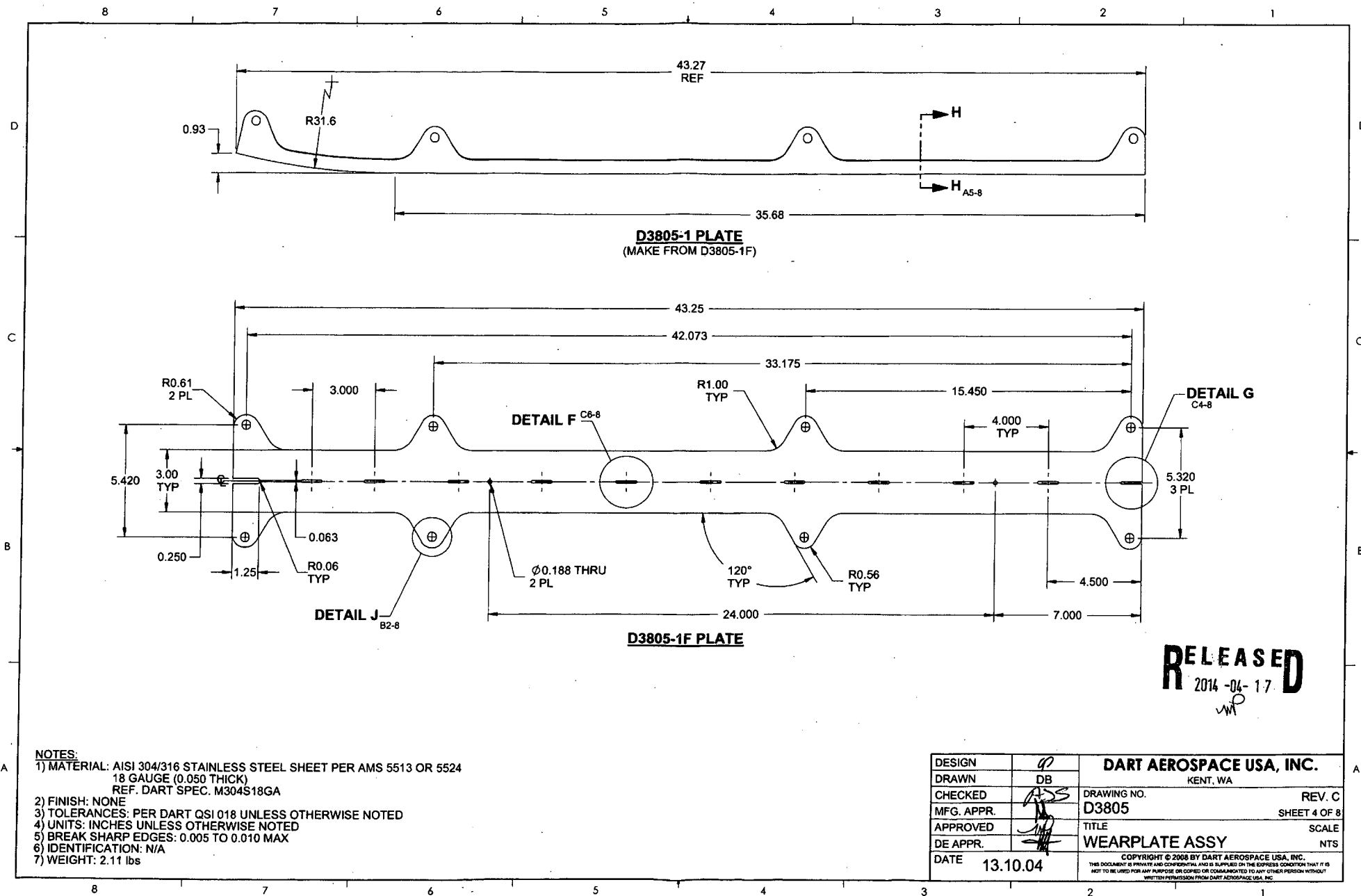
VIEW D-D C1-3

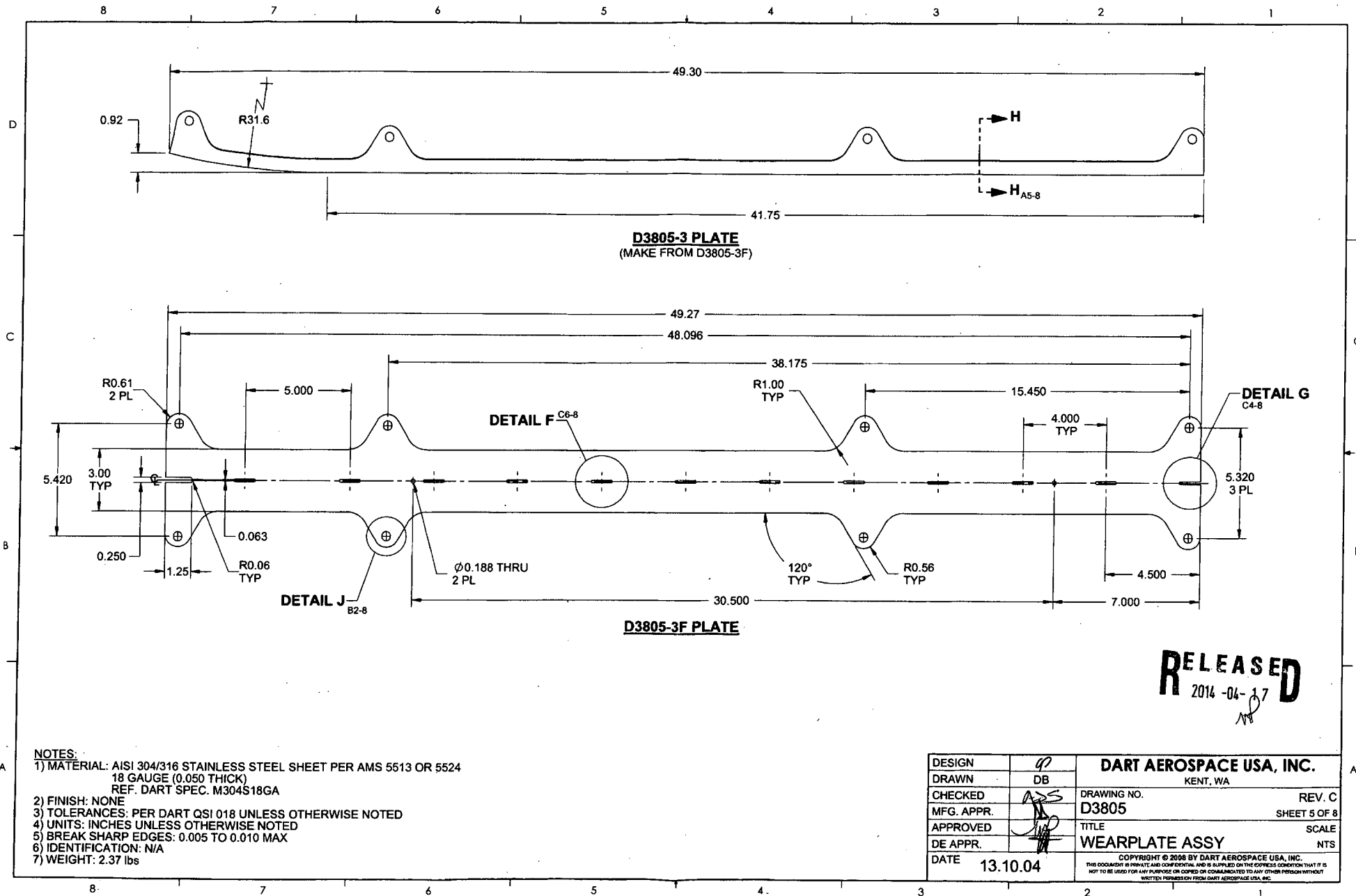
RELEASED
2014-04-17

NOTES:

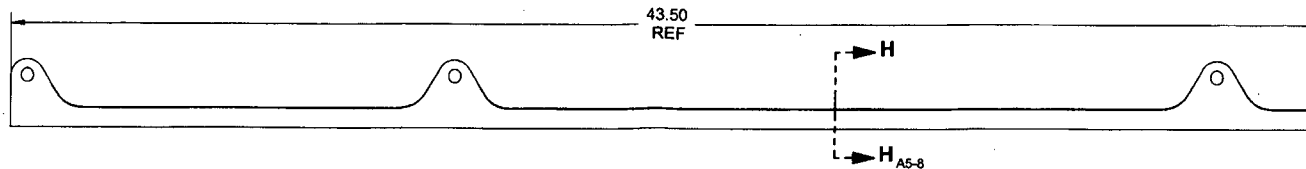
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
- 8) WELDING: PER QSI 004
- 9) 2058B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3805-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DB	D3805	SHEET 3 OF 8
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	WEARPLATE ASSY	NTS
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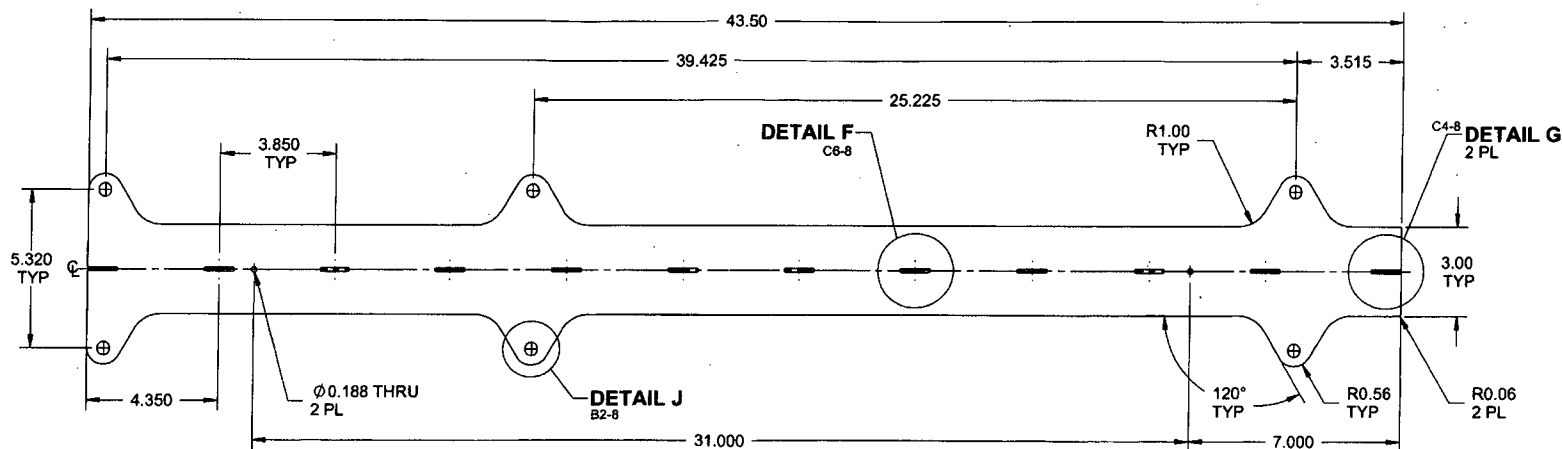




8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

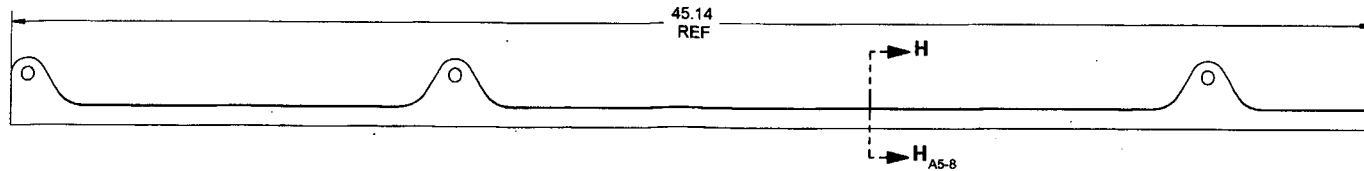
RELEASED
2014-04-17
MP

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.06 lbs

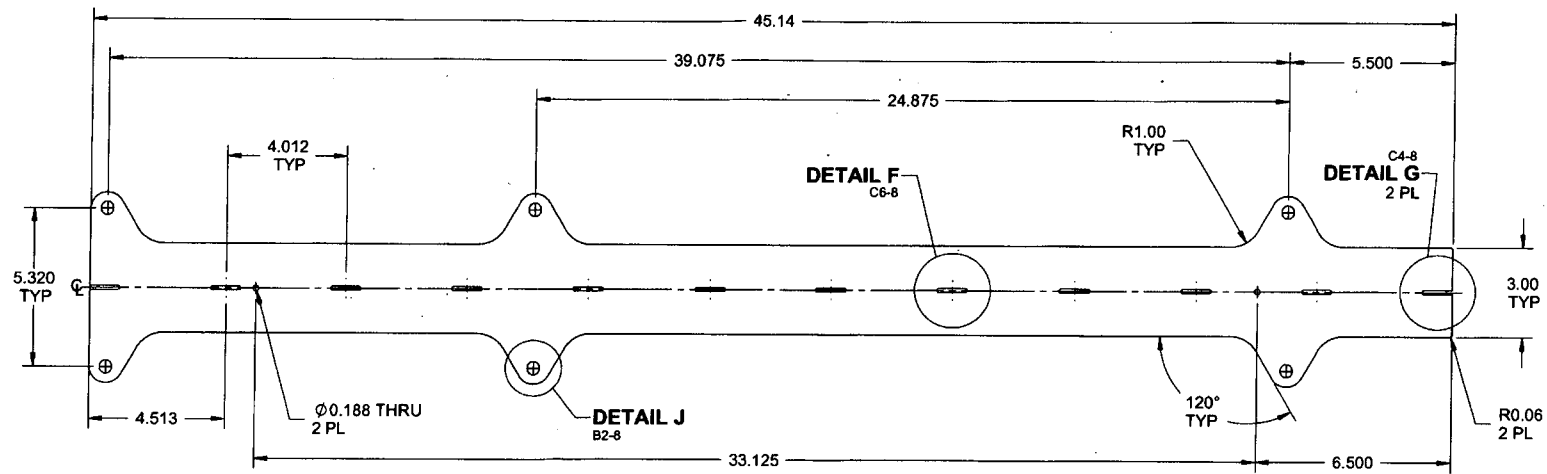
DESIGN	<i>Q</i>	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>MP</i>	D3805	SHEET 6 OF 8
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



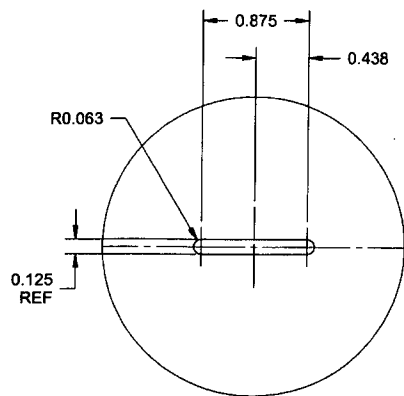
D3805-7F PLATE

RELEASED
2014-04-17

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.13 lbs

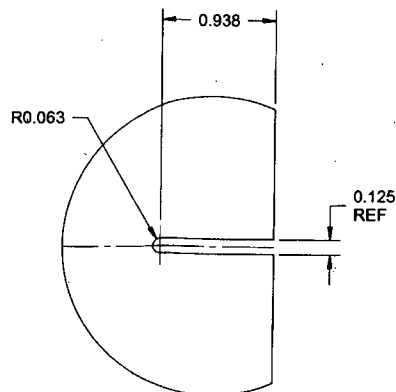
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



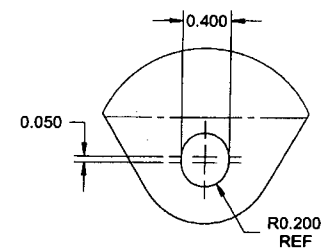
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SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



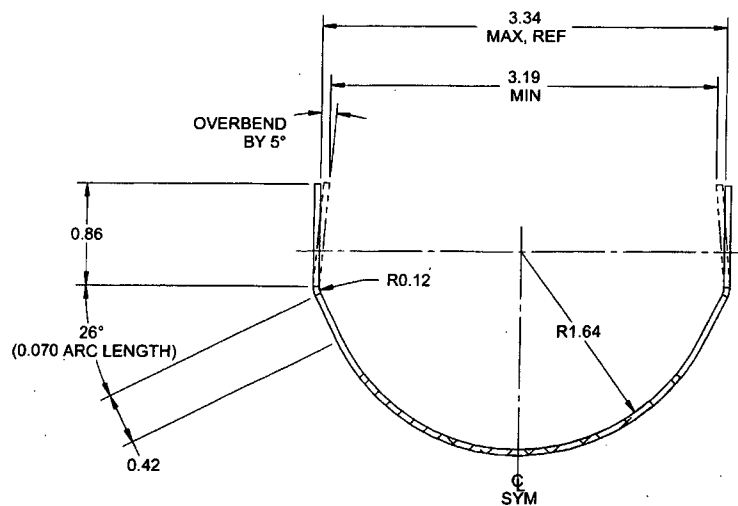
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

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2014-04-10

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DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 8 OF 8
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